

Date: Tuesday, 4/17/2007 3:53:24 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/355 AS X-TUBE AFT
Job Number : 31908	
Estimate Number : 12486	
P.O. Number : <i>NIA</i>	Part Number : D350748201
This Issue : 4/17/2007 S.O. No. : <i>NIA</i>	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 31907	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 5/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-07-05 JLM	
Est Rev: B Update qty of MS21042L5 06-09-12 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*15.07/08/22*

Comment: Photocopy bluefile & type labels per PPPD350-748-201	CHG001
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*CP 07/08/22*

2.0	31908A	X-TUBE AS 350/355 HI AFT UNDER REVIEW
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Comment: Sub-Component X-TUBE AS 350/355 HI AFT
D350-748-241 B <i>31908A</i>

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
350 SADDLE
Batch: <i>628794</i>

*CP*

5.0	D35011	BUSHING
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
BUSHING
Batch: <i>628478</i>

*CP**07/08/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 31908

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M105057-

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M102552-

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850-

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M104215-

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M104156-

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M102552-2 M103914

12.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104118(3H)- M104547(1X)-

EP 07/08/220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 02/08/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 31908

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*Er 7/8/22*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*A 7/8/22 SP*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*7/8/23 (1)*

Job Completion



*U 7/8/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:41 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 31908A  
 Estimate Number : 12483  
 P.O. Number : N/A  
 This Issue : 4/17/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : 31907A  
 Drawing Name : X-TUBE AS 350/355 HI AFT UNDER REVIEW  
 Part Number : D350748241  
 Drawing Number : D350-748-241 *OK 07.04.18*  
 Project Number : N/A  
 Drawing Revision : *07*  
 Material : N/A  
 Due Date : 5/30/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : *07.04.18*  
 Comment : Est Rev: A New Issue 06-07-05 JLM  
 Est Rev: B Update cadplate process 06-09-12 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-241 CHG001

N/A

~~07.04.18~~

2.0 D6018125 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD X 2.000" ID

Batch: *B27472*
*07.04.18*

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

*07.04.18*

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*07.04.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 4/17/2007 3:53:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31908A

Part Number: D350748241

Job-Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241

MS 07/04/27

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/04/27

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RC 07/04/27

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

Jb 7-5-9

9.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3777

CL 07/05/15 ①

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

RC 07/06/04 ①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

207-07-04 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31908A

Part Number: D350748241

Job Number:



Seq. #: Machine Or Operation: Description:

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Oil inside of tube with LPS-3.

A/R LPS-3

Batch:

M104161

EA/EL

070710

13.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

EL EA 7-7-10

14.0 QC6 DIMENSIONAL CHECK

QC6



DIMENSIONAL CHECK

EA/EL 7-7-10



Comment: DIMENSIONAL CHECK

15.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

DP 7-7-16

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
Set-up drill table as per QSI 010

EA 070711

3-Deburr

EA 070711

4-Engrave Part # and Batch # as per Dwg D350-748-241

EA/EL

16.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

EA/EL 7-7-17

17.0 OUTSIDE SERV.10 OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4203

EA 070718

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadmium Plate per AMS QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/11/2007 3:53:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31908A

Part Number: D350748241

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

7/8/17 SP (15)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/08/17 (46)

20.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2  
2-Paint Outside of Tube as per Dart QSI 005 4.2

7 ml 07 08 19

(1)

21.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint  
Then, Wrap in plastic bag to protect from scratches

RT 07 08 21

22.0 D35021 SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
SUPPORT  
Batch: 28476

RT 07-08-21

23.0 D2856400 Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)  
Abrasion Strip 7.10" long x2  
Batch: 32020

RT 07-08-21

24.0 ALS41032225 Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Insert  
Batch: 19393

RT 07-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 4/17/2007 3:53:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31908A

Part Number: D350748241

Job-Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 104885

RT 07-08-21

26.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 104902

RT 07-08-21

27.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

RT 07-08-21

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

RT 07-08-21

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20 (45)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

31908

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 22 Date: 01/08/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 4/17/2007 3:53:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT UNDER REVIEW

Job Number: 31908A

Part Number: D350748241

Job-Number:



Seq. #:

Machine Or Operation:

Description :

31 0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
D 07/08/23

Job Completion



u 07-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31908A
<b>Description:</b> Crosstube Assembly (AS350/355 High Aft)		<b>Part Number:</b>	D350-748-241
<b>Inspection Dwg:</b> D350-748-241 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

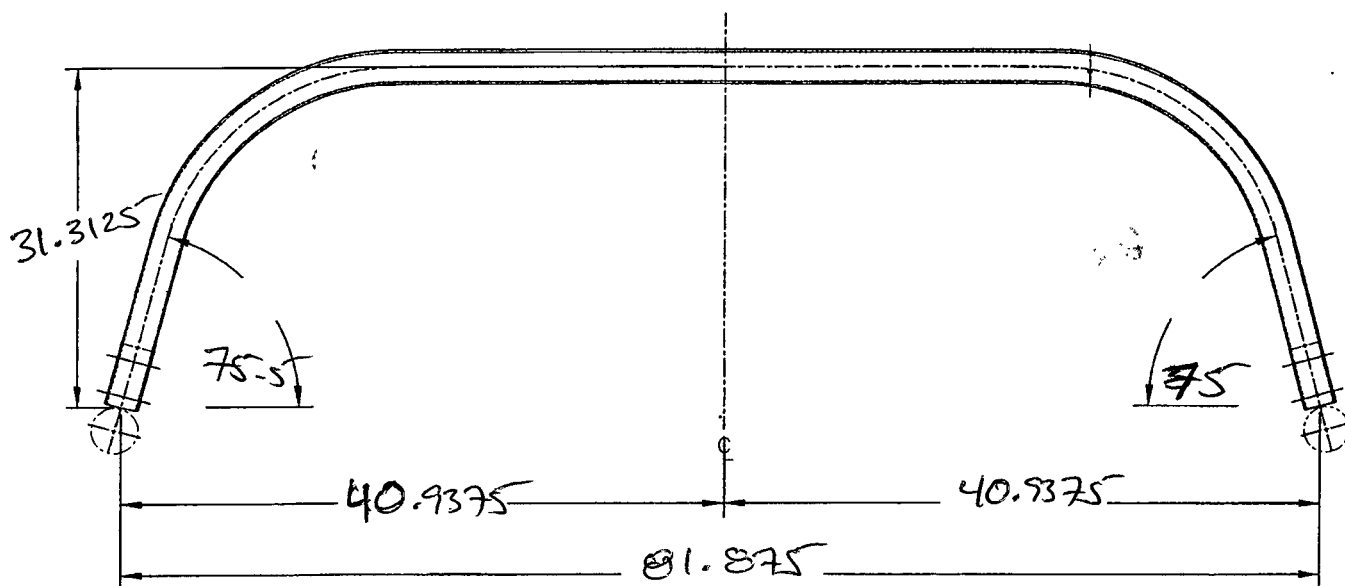
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	✓			
	2.180	+0.005/-0.000	2.180	✓			
	2.180	+0.005/-0.000	2.180	✓			
	2.208	+0.005/-0.000	2.208	✓			
	2.234	+0.005/-0.000	2.234	✓			
	2.253	+0.005/-0.000	2.253	✓			
	2.272	+0.005/-0.000	2.272	✓			
	2.299	+0.005/-0.000	2.299	✓			
	0.063	+/-0.010	.064	✓			
	4.26	+/-0.030	4.26	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	.500	✓			
SIDE B	2.240	+0.005/-0.000	2.244	✓			
	2.180	+0.005/-0.000	2.184	✓			
	2.180	+0.005/-0.000	2.184	✓			
	2.208	+0.005/-0.000	2.202	✓			
	2.234	+0.005/-0.000	2.238	✓			
	2.253	+0.005/-0.000	2.257	✓			
	2.272	+0.005/-0.000	2.276	✓			
	2.299	+0.005/-0.000	2.302	✓			
	0.063	+/-0.010	.063	✓			
	4.26	+/-0.030	4.260	✓			
	R0.063	+/-0.010	.063	✓			
	R0.50	+/-0.030	.500	✓			
	122.70	+/-0.060	122.70	✓			

<b>Measured by:</b> S.F.	<b>Audited by:</b> SK	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/27	<b>Date:</b> 07/04/30	<b>Date:</b>	N/A

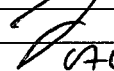
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	


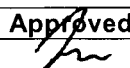
DART AEROSPACE LTD		Work Order:	31908A
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241      Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM 	

**DART****RELEASED**06-10-31 *HH*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1.	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

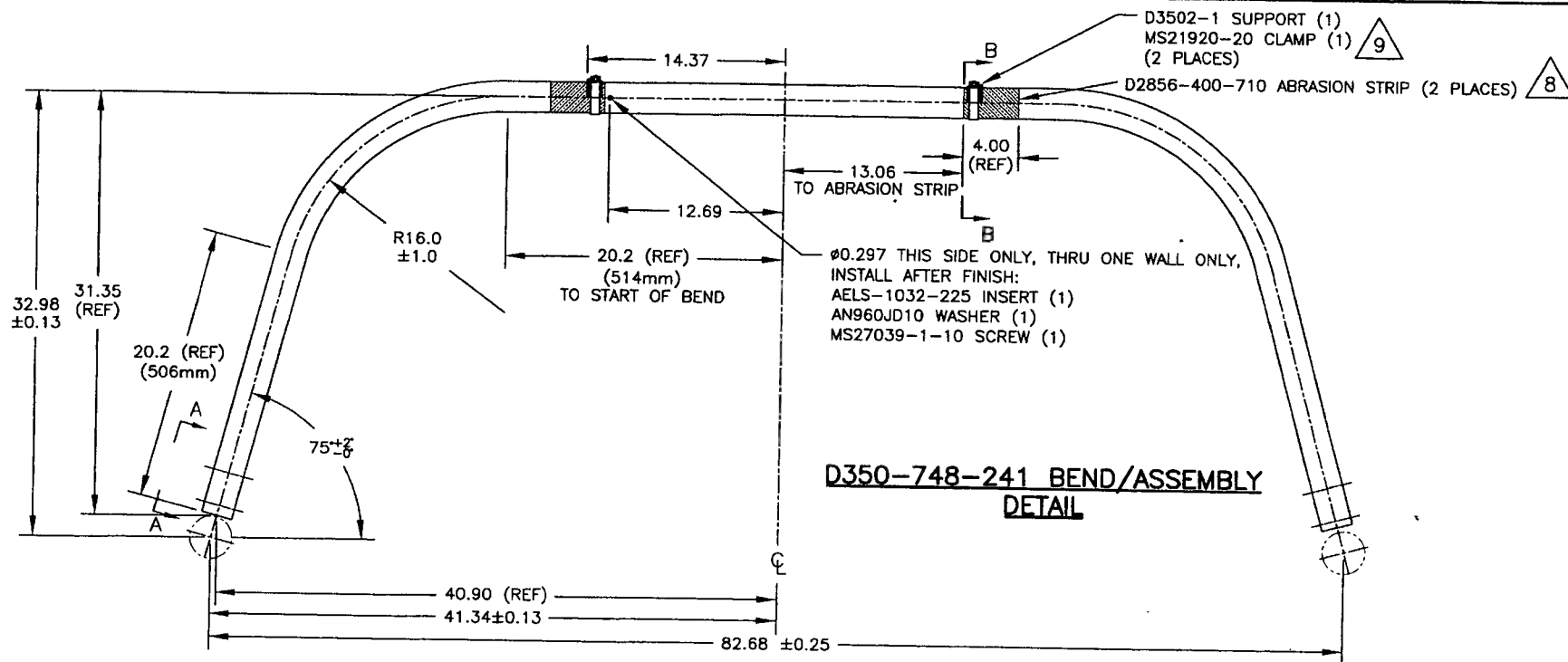
**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

**UNDER REVIEW**07.07.16  
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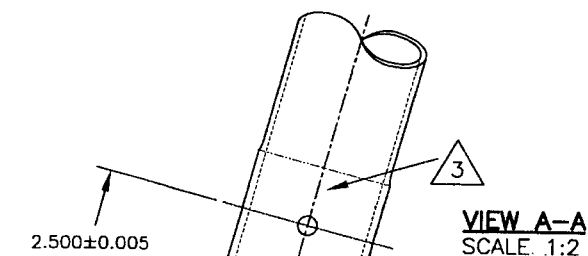
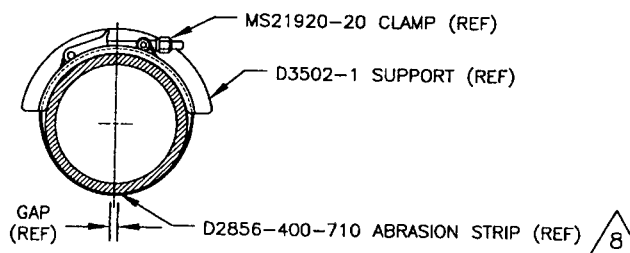
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**D350-748-241 BEND/ASSEMBLY  
DETAIL**

**SECTION B-B  
SCALE 1:2**



Ø0.323 ±0.005 (THRU, TYP)  
HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF,  
TO BE DRILLED AFTER BENDING

0.780  
0.500

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070418P

**UNDER REVIEW**

07/2/16

**RELEASED**

061031

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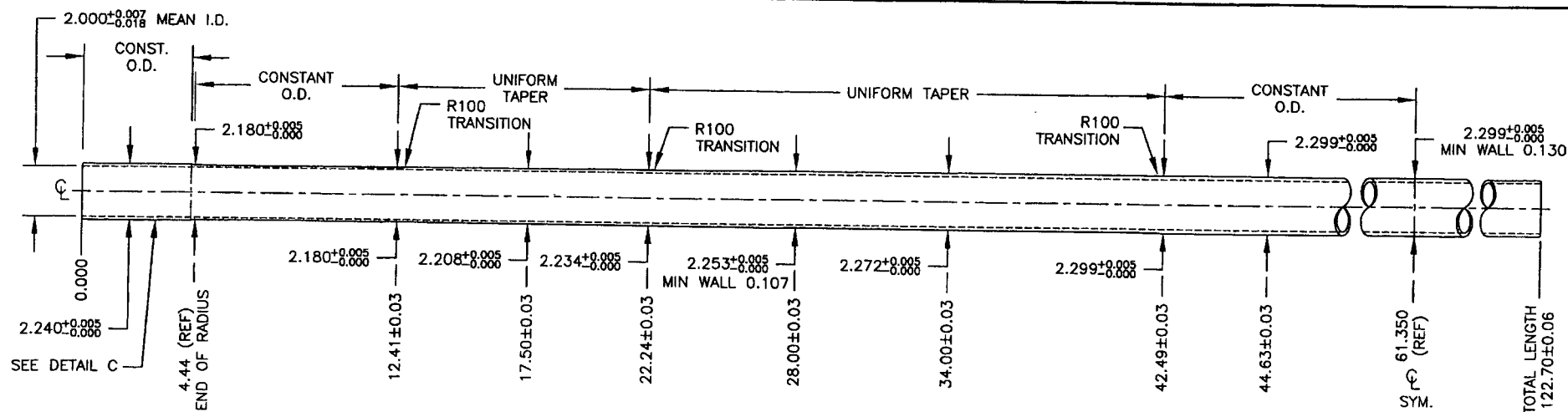
DESIGN	9P	DRAWN BY	9P	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D350-748-241
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI AFT)	REV. D	SHEET 2 OF 3
				SCALE	1:8

1165

+ 06185  
- 0.3305







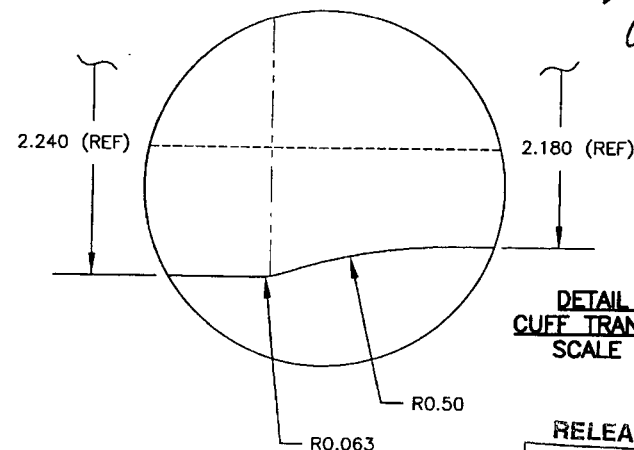
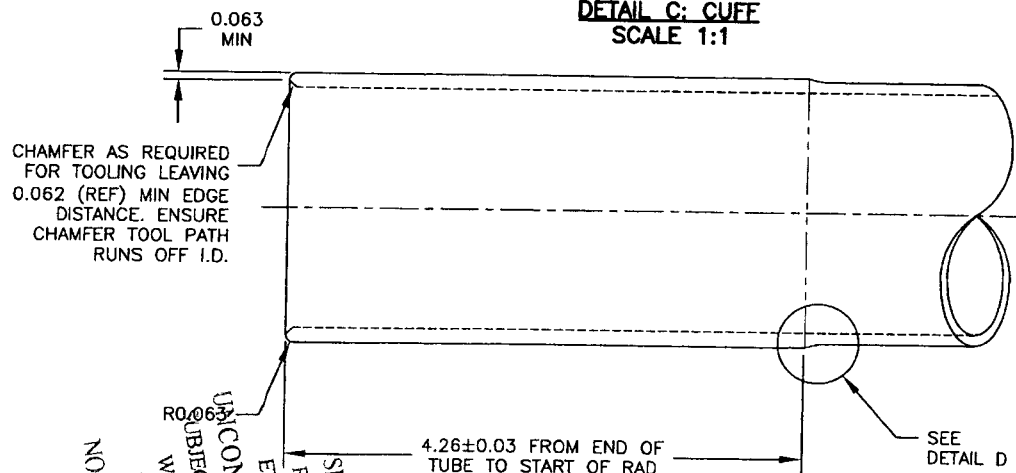
# **D350-748-241 MACHINING DETAIL**

UNDER REVIEW

07-02-06

07-02-06

## **DETAIL C: CUFF SCALE 1:1**



## **DETAIL D: CUFF TRANSITION SCALE 9:1**

RELEASED

06-10-31

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DESIGN	q7	DRAWN BY	q7	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D350-748-241
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI AFT)	REV. D	SHEET 3 OF 3
		SCALE	1:4		

NO. 2108A  
WORK ORDER  
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# VAC AERO

INTERNATIONAL INC.

## RELEASE NOTE

GST No.: R105468102

OAK 87500-1

05/29/2007

MM/DD/YYYY

PAGE: 1

2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
05/29/2007	EPIC 4300450343	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3777		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141, 241 Process Specifications: HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS CHECKED AS PER ASTM E-18 HRC 40-43 MATERIAL: 4130 SAND BLASTED P/S# 59141 6 PIECES P/N D350-748-141, S/N B31901A, B31902A, B31903A, B31904A, B31905A, B31906A 4 PIECES P/N D350-748-241, S/N B31907A, B31908A, B31909A, B31910A NOTE: NO SERIAL NUMBERS FOUND ON PARTS	EA	10	10	100% HARDNESS TESTED 10 pcs → 42/43 HRC V.A.I.O. TM. 27 Q.C.

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector

SPECIAL PROCESSING FURNACE EQUIPMENT



HEAT TREATING



**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Aug-13-2007

**CONSIGNEE TO:** Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawksbury, ON K6A 1K7

**W/O #:** 68800

**INVOICE #:** 35484

**CONTRACT OR  
PURCHASE ORDER #**

**4203**

**DESCRIPTION:** SKID

**QTY** 1

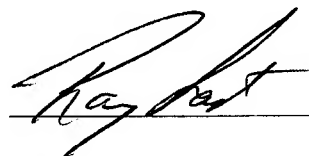
**P/N #** D350748241

**S/N #** B31908A

**CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1 MPI IAW  
ASTM E 744. AND ACCEPTED BAKE HEAT CHARTS #8066 & 8136**

**CERTIFICATE:** I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.

**Approved Inspector:**

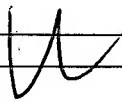
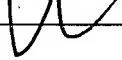


**R. LAST**



Date: Thursday, 23/08/2007 10:54:14 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERWD350-748
Job Number	: 34248		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 23/08/2007 S.O. No. : N/A	Drawing Number	: ECN 1012
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 30/08/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO STK  
 PER ECN 1012

D350-748-101 BATCHES:

31904, 31913, 31902

D350-748-201 BATCHES:

31907, 31910, 31908

RETURN TO STK

7/8/24 SP

2.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion



U 07-08-24

